



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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11787

RBEA62316-1
Job Sheet 188101



Part No: RBEA62316-1

Job Qty: 1 pcs

Part Name: Case 1



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/3/19

Job Tracking No:

Due Date: 3/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEA62316 Rev.C IPP Rev. A 18.12.20 New issue DP Verify DD/IPP Rev. C 19.03.11 drawing revision
DP Verify DD

Ship Via:



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S170163



Part: RBEA62316-1

Job No: 188101

Serial No/Batch: S170163

Revision: C

Inspector:

Exp Date:

Instructions:

Date: 04/06/19

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
95	Small Fab - 1	1 pcs	3/20/19	0.00	1.00		Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
100	Small Fab - 2 - B4B	1 pcs	3/20/19	0.00	1.00		Small Fab - 1 - B4B		MLL
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
110	QC 5	1 pcs	3/20/19	0.00	0.00		QC 5 - 10		DAG 19 9-00
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
120	Packaging 3-1 - Stock - B4B	1 pcs	3/20/19	0.00	0.00		Packaging 3 - 1 - B4B		DAG 21 9-00 APR 08 2019
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
130	QC 21 - FG	1 pcs	3/20/19	0.00	0.00		QC 21 - FG - 21		DAG 21 APR 08 2019
Part Op 100 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case Descriptions: APP-1650-E 3-Debur holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBEA62316-11 to RBEA62316-9 foam as per DWG. 6-Glue foam to case and pack case as per DWG. See note.									

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1650-E	Case	1 Ea (1 ea)	95-Small Fab - 1	5152171
RBE1X46-182-024p	groove nut	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5151084
RBE1X53-174-739-2p	thurst piece	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5166982
RBE1X54-176-875	Press Tool	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5165088
RBE1X56-122-294	Push-Out Device	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5165290
RBEA62316-11	Placard	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5154403
RBEA62316-15	Hand Pump	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5156000
RBEA62316-17	5 Ton Jack	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5156004
RBEA62316-19	12 Ton Jack	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5156009
RBEA62316-3	Bottom Foam, Top Shelf use in case APP-1650-E	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5152172
RBEA62316-31	Hose Assembly	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5156010
RBEA62316-5	Bottom Foam, Lower Shelf use in case APP-1650-E	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5152186
RBEA62316-7	Top Shelf Stiffener use in case APP-1650-E	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5152173
RBEA62316-9	Top Foam use in case APP-1650-E	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5152174
RBEL133M-6705-101	Swash Plate Fixation Clamp	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5028936
RBEVR-L11-0010-002-1	Threaded Puller	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5163132
RBEVR-L11-0010-002-2	Press Tool	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5161224
RBEVR-L11-0010-002-B	Rod Assembly	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5168866
RBEVR-L11-0010-002-D	Rod Assembly	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5167984
RBEVR-L11-0010-003-B	Spacer	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5161048
RBEVR-L11-0010-004-B	Press Tool	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5168863
RBEVR-L11-0010-005-B	Press Tool	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5168211

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
95-Small Fab - 1	APP-1650-E	1	7	0
100-Small Fab - 2 - B4B	RBE1X46-182-024p	1	1	0
	RBE1X53-174-739-2p	1	1	0
	RBE1X54-176-875	1	4	0
	RBE1X56-122-294	1	5	0
	RBEA62316-11	1	2	0
	RBEA62316-15	1	2	0
	RBEA62316-17	1	2	0
	RBEA62316-19	1	2	0
	RBEA62316-3	1	2	0
	RBEA62316-31	1	2	0
	RBEA62316-5	1	2	0
	RBEA62316-7	1	2	0
	RBEA62316-9	1	2	0
	RBEL133M-6705-101P	1	0	0
	RBEVR-L11-0010-002-1	1	5	0
	RBEVR-L11-0010-002-2	1	2	0
	RBEVR-L11-0010-002-B	1	0	0
	RBEVR-L11-0010-002-D	1	0	0
	RBEVR-L11-0010-003-B	1	2	0
	RBEVR-L11-0010-004-B	1	0	0
	RBEVR-L11-0010-005-B	1	2	0

Part Specifications

Specifications could not be found.

9/19



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Job Sheet 188101

17757



Part No: RBEA62316-1

Job Qty: 1 pcs

Part Name: Case 1



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/3/19

Job Tracking No:

Due Date: 3/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEA62316 Rev.2 IPP Rev. A 18.12.20 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	3/20/19		0.00	1.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	3/20/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
120	Packaging 3-1 - Stock - B4B	1 pcs	3/20/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
130	QC 21 - FG	1 pcs	3/20/19		0.00	0.00	QC 21 - FG - 21		

Part Op 100 - 1-Glue placard RBEA62316-11 to RBEA62316-9 foam as per DWG. 2-Glue foam to case and pack case as per Descriptions: DWG. See note.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1650-E	Case	1 Ea (1 ea)	100-Small Fab - 1	
RBE1X46-182-024	Groove Nut	1 pcs (1 ea)	100-Small Fab - 1	
RBE1X53-174-739-2	Thrust Piece	1 pcs (1 ea)	100-Small Fab - 1	
RBE1X54-176-875	Press Tool	1 pcs (1 ea)	100-Small Fab - 1	
RBE1X56-122-294	Push-Out Device	1 pcs (1 ea)	100-Small Fab - 1	
RBEA62316-11	Placard	1 pcs (1 ea)	100-Small Fab - 1	
RBEA62316-15	Hand Pump	1 (1 ea)	100-Small Fab - 1	
RBEA62316-17	5 Ton Jack	1 (1 ea)	100-Small Fab - 1	
RBEA62316-19	12 Ton Jack	1 (1 ea)	100-Small Fab - 1	
RBEA62316-3	Bottom Foam, Top Shelf	1 (1 ea)	100-Small Fab - 1	
RBEA62316-31	Hose Assembly	1 (1 ea)	100-Small Fab - 1	
RBEA62316-5	Bottom Foam, Lower Shelf	1 (1 ea)	100-Small Fab - 1	
RBEA62316-7	Top Shelf Stiffener	1 (1 ea)	100-Small Fab - 1	
RBEA62316-9	Top Foam	1 (1 ea)	100-Small Fab - 1	
RBEL133M-6705-101	Swash Plate Fixation Clamp	1 pcs (1 ea)	100-Small Fab - 1	
RBEVR-L11-0010-002-1	Threaded Puller	1 pcs (1 ea)	100-Small Fab - 1	
RBEVR-L11-0010-002-2	Press Tool	1 pcs (1 ea)	100-Small Fab - 1	
RBEVR-L11-0010-002-B	Rod Assembly	1 pcs (1 ea)	100-Small Fab - 1	
RBEVR-L11-0010-002-D	Rod Assembly	1 pcs (1 ea)	100-Small Fab - 1	
RBEVR-L11-0010-003-B	Spacer	1 pcs (1 ea)	100-Small Fab - 1	
RBEVR-L11-0010-004-B	Press Tool	1 pcs (1 ea)	100-Small Fab - 1	
RBEVR-L11-0010-005-B	Press Tool	1 pcs (1 ea)	100-Small Fab - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	APP-1650-E	1	3	0
	RBE1X46-182-024	1	0	0
	RBE1X53-174-739-2	1	0	0
	RBE1X54-176-875	1	0	0
	RBE1X56-122-294	1	0	0
	RBEA62316-11	1	0	0
	RBEA62316-15	1	0	0
	RBEA62316-17	1	0	0
	RBEA62316-19	1	0	0
	RBEA62316-3	1	0	0
	RBEA62316-31	1	0	0
	RBEA62316-5	1	0	0
	RBEA62316-7	1	0	0
	RBEA62316-9	1	0	0
	RBEL133M-6705-101	1	0	0
	RBEVR-L11-0010-002-1	1	0	0
	RBEVR-L11-0010-002-2	1	0	0
	RBEVR-L11-0010-002-B	1	0	0
	RBEVR-L11-0010-002-D	1	0	0
	RBEVR-L11-0010-003-B	1	0	0
	RBEVR-L11-0010-004-B	1	0	0
	RBEVR-L11-0010-005-B	1	0	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

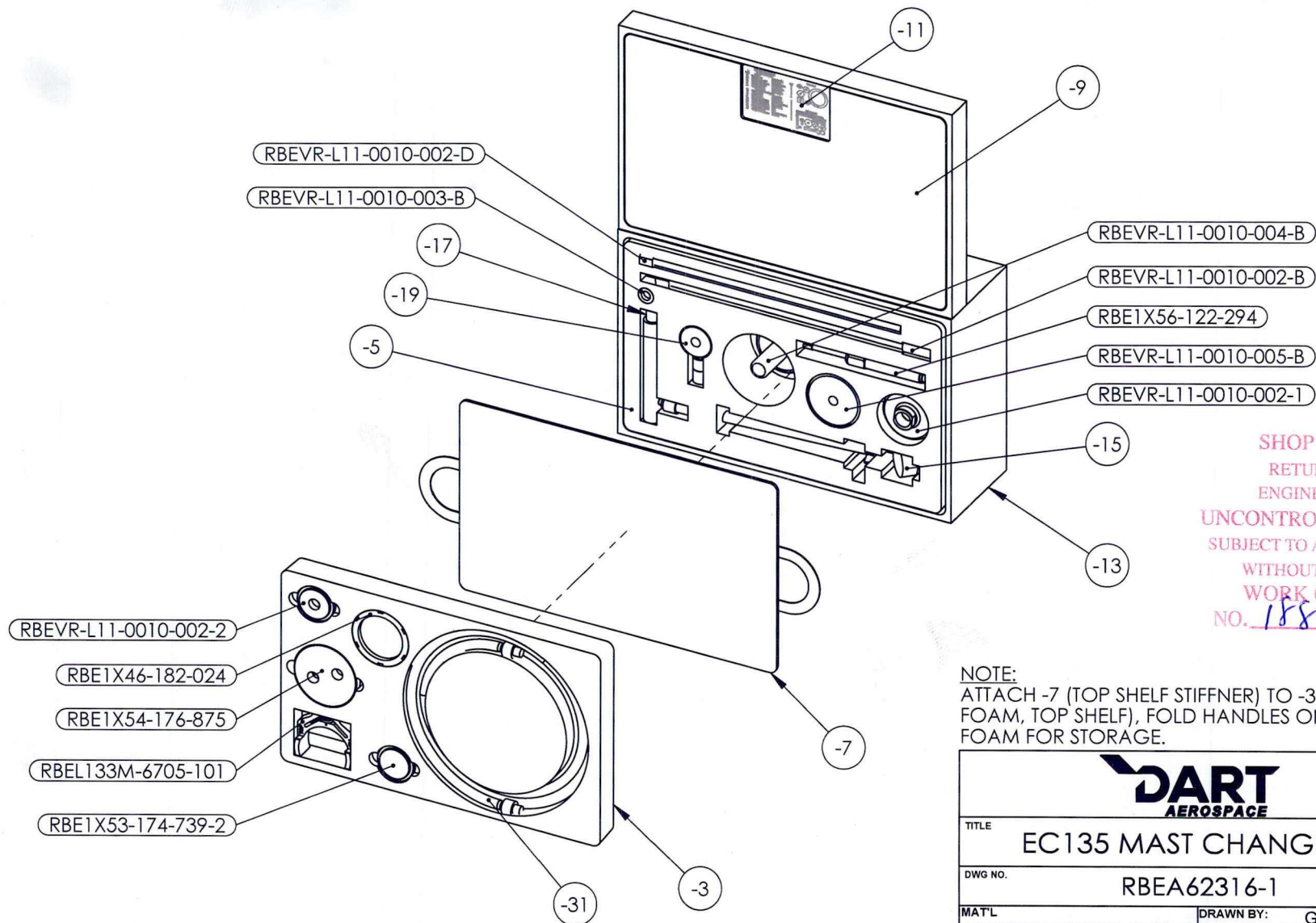
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
2	15-0219	-1 REPLACED TOOL DASH NUMBERS WITH TOOL NUMBERS.	9/1/2015	DPD
				JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 188101 MCL
1901-03

NOTE:
ATTACH -7 (TOP SHELF STIFFNER) TO -3 (BOTTOM
FOAM, TOP SHELF), FOLD HANDLES ON TOP OF
FOAM FOR STORAGE.

DART AEROSPACE	
TITLE EC135 MAST CHANGE KIT	
DWG NO. RBEA62316-1	REV 2
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/8 ANGLES ± 5° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: GILBERT APPROVED: D Weil HEAT TREAT FINISH SPEC USED ON MODEL EC135
SCALE 1:12	DATE 4/11/2012
SHEET 2 OF 12	